

Date: Tuesday, 21/10/2008 8:14:36 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSY WELDMENT
Job Number	: 42753		
Estimate Number	: 13418		
P.O. Number	:	Part Number	: PB674300107
This Issue	: 21/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.5
First Issue	: / /	Project Number	: N/A
Previous Run	: 41362	Drawing Revision	: B1
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 28/10/2008
Checked & Approved By	: <u>MF 08-10-21</u>	Qty:	2
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Base Assembly

batch:- B41509

MF

08-10-21

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- B41485

MF

08-10-21

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- B41483

MF

08-10-21

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Square Tubing

batch:- B41487

MF

08-10-21

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Square Tubing

batch:- B40595

MF

08-10-21

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Job Number: 42753

Part Number: PB674300107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001201	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Square Tubing 40592
batch:- ~~B41572~~

MF 08-10-21

7.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Square Tube
batch:- B41789

MF 08-10-21

8.0	PB6743001207	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Square Tube
batch:- B42603

MF 08-10-21

9.0	PB6743001219	Angled Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Angled Male Eye
batch:- B40041

MF 08-10-21

10.0	D34405	Contoured Detent Clip Base (Supersedes B
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Contoured Detent Clip Base
batch:- B41454

MF 08-10-21

11.0	D34407	Detent Clip Base (Supersedes B67-43001-2
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Detent Clip Base
batch:- B41204

MF 08-10-21

12.0	D344015	Contoured Male Eye (Supersedes B67-43001
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Contoured Male Eye
batch:- B41202

MF 08-10-21

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Job Number: 42753

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(x2)

Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

PL 08-10-27
8.10.27

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/28 (2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/28 (1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

mask inside of D3440-5, D3440-7 and D3440-15 prior to paint*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

12:55

OVEN TEMPERATURE:

320°

FINISH TIME:

1:25

08/10/28 (2)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/28 (2)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Carl

MF 08-10-29

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/29 (2)

Job Completion



MF 08-10-29

